

# Work Order ID 63425

Monday, November 01, 2010 11:49:52 AM



Page 1

Item ID:	D3825-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket End)					
Start Date:	11/1/2010	Start Qty:	6.00			
Required Date:	11/5/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:		Date:	10-11-01	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3825	Rev A								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3825-1 rib as per dwg D3825								
	2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825								
	3- c'sink hole as per dwg								
	4- remove identification markings								
	5- deburr								
	6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825								
	A/R S.S. Rod Batch: 111585								
	7- grind bushing weld flush where indicated on dwg D3825								
	8- deburr if necessary								

SAO 10-11-05

lpl 10/11/23

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3825-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket End)

Start Date: 11/1/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 11/5/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10.11.23

6

0

BE10/11/23

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.11.23

x6

150

Identify as per dwg &amp; Stock Location: B/C

0.00



Packaging

Memo

0.00

Packaging

10.11.23

W/O:		WORK ORDER CHANGES					
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Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 11/1/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/5/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/23 *[Signature]*  
MF  
10-11-23

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Monday, November 01, 2010 11:49:56 AM

Page 1

Work Order ID: 63425

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)



Start Date: 11/1/2010

Required Date: 11/5/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3 Manufactured No



Spacer Bushing

100

Each

20.0000

1

6



~~SAT 10-11-05~~

Location

Loc Qty

Loc Code

WA

20

58974

1

60320

1

60952

11

62108

7

Pl 10-11-23

(5) (1)

D3759-1



Bushing

Manufactured No

100

Each

40.0000

1

6



~~SAT 10-11-05~~

Location

Loc Qty

Loc Code

ST084

21

56942

21

WA

19

54072

9

61379

10

Pl 10-11-23

(3) HHH



B63875 -> (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 2

Monday, November 01, 2010 11:49:56 AM

Work Order ID: 63425



Parent Item: D3825-041



Parent Item Name: Rib Assembly (Basket End)

Start Date: 11/1/2010

Required Date: 11/5/2010

Start Qty: 6.00

Required Qty: 6.00

M304TS0.750W.065

Purchased

No

100

f

468.6990

2.125

13.42105



SAP 10-11-05

304 SQ Tube .75x.75x.065W

## Location

## Loc Qty

## Loc Code

MAT

315.30255

112398

0

114482

0.0002

115494

32.8937

115593

282.40865

WA

153.396485

114520

0.527385

115274

16.027

115901

136.8421

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

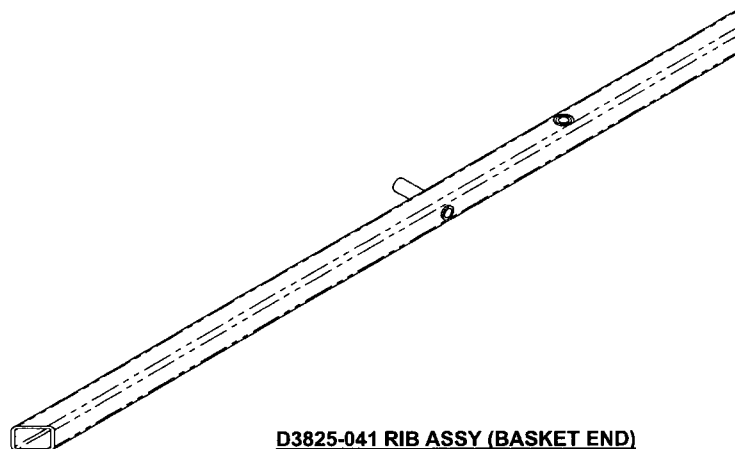
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



**D3825-041 RIB ASSY (BASKET END)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63425  
BP 10-11-01

RELEASED  
08/11/23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3825  
REV. A  
SHEET 1 OF 3  
TITLE RIB ASSY (BASKET END)  
SCALE NTS

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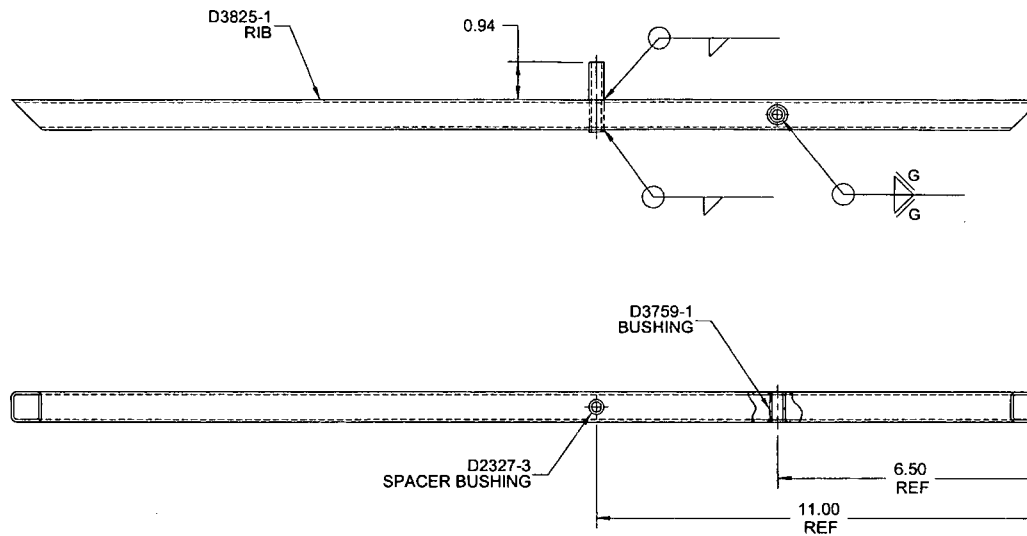
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**NOTE:** Date & initial all entries



**D3825-041 RIB ASSY (BASKET END)**

**RELEASED**  
08/11/18 JWP

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
APPROVED	JWP	TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	08.09.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

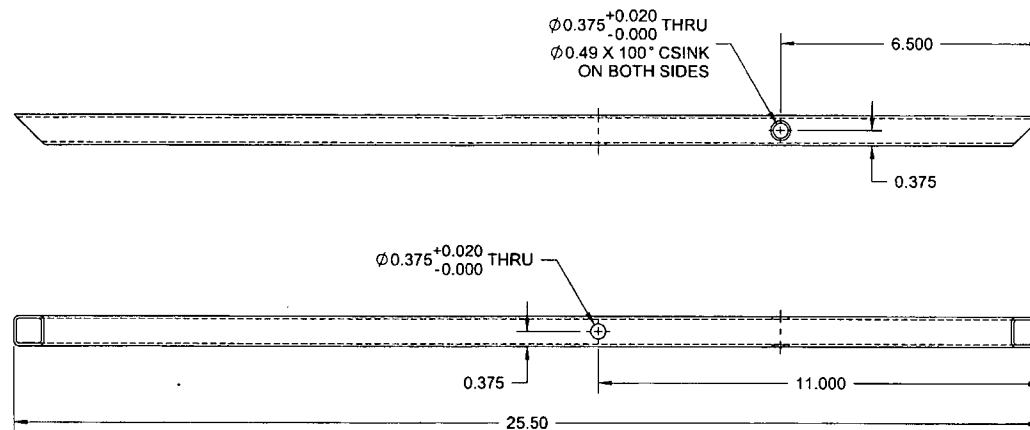
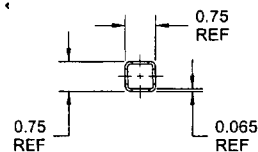
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**NOTE:** Date & initial all entries



**D3825-1 RIB**

*wb62825*

**RELEASED**  
08/11/13 NPB

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.18 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3825</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSY (BASKET END)</b>	NTS
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